PRC®

protective coatings

caulking compounds

sealants • adhesives

TECHNICAL DATA SHEET

PR-1321 CLASS A

USE

1. Access door sealant for integral fuel tanks and pressurized cabins.
2. Gasket for removable parts.
3. Strippable coating.

DESCRIPTION

PR-1321 Class A is designed for sealing faying surfaces where easy separation of the joined surfaces is required. The sealant has low adhesion and forms a tough, rubbery gasket that molds itself to fill all irregularities between two surfaces. Integral fuel tanks may be filled with fuel 45 minutes after application of sealant.

PR-1321 Class A is a red, polysulfide-base, liquid polymer. The mixed compound is of fluid consistency which can be applied easily by brush in thicknesses up to 20 mils; but once applied, will not flow from vertical or overhead surfaces. It cures to a solid rubber after being mixed with an accelerator.

SPECIFICATIONS

Meets the requirements of MIL-S-8784B, Class A.

APPLICATION PROPERTIES (Typical)

Color Base Compound	Red
Accelerator	Red-Brown
Mixing Ratio	10 to 1 by weight (base compound: accelerator)
Nonvolatile Content, minimum	90%
Viscosity	
Brookfield Spindle #4 @ 10 rpm	240 poises

Application Life and Cure Time (At 75°F, 50% relative humidity)

	Minimum Application Life (in hours)	Maximum Tack Free Time (in hours)	Maximum Time to 25 Shore (in hours)	Ultimate Cure (in days)
A-½	½	10	18	2
A- 2	2	24	36	4

PERFORMANCE PROPERTIES (Typical)

Color	Red
Specific Gravity	1.45
Hardness, Shore A	38
Adhesion to Aluminum, peel	½ lb/inch of width
Adhesion to Other Materials	Has low adhesion to steel, stainless steel, titanium, zinc, cadmium, chromium, magnesium, tin, lead, glass enamel and porcelain.
Tensile Strength	230 psi
Ultimate Elongation	350%
Modulus at 100% Elongation	100 psi
Temperature Range	−100°F to +225°F

PURCHASING DATA

PRODUCT DESIGNATION

When ordering this product, designate PR number, class, and dash number as follows:

PR-1321 A-½	Minimum Application Life	30 minutes
PR-1321 A- 2	Minimum Application Life	2 hours

PACKAGING

PR-1321 Class A may be purchased in the following types of packages:

Standard Containers

Designation	Base Compound Container	No. per Case
½ pt. kit — 3½ fl. oz.	½-pt. can	16
½ pt. kit — 6 fl. oz.	½-pt. can	16
Pint kit — 12 fl. oz.	1-pt. can	16
Quart kit — 24 fl. oz.	1-qt. can	9
Gallon kit — 96 fl. oz.	1-gal. can	4
50 gallons	55-gal. open-top drum	

NOTE: The fluid ounce content is the amount of base compound (128 fluid ounces per gallon). Kits are furnished with a premeasured quantity of base compound and accelerator individually packaged and assembled as a single unit. Bulk quantities of 50 gallons are accompanied by sufficient accelerator individually packaged. Kits are designed so that adequate space is available in the base compound container for addition of accelerator and mixing.

Semkit® Two-Part Sealant Cartridges

Designation	Approximate Total Contents	Container	Kits per Case
Model 655	2 fl. oz.	2½ oz. cartridge	24
Model 654	5 fl. oz.	6 oz. cartridge	24

NOTE: Semkit Two-Part Sealant Cartridges are furnished with a premeasured quantity of base compound and accelerator packaged in a plastic cartridge equipped for mixing the compound in the cartridge.

SHIPPING CLASSIFICATION: Caulking or Glaziers' Compound, NOI

Low Temperature Flexibility	−70°F
Compression Set	8 psi constant load for 16 hrs. at 120°F, 15%
Fuel Contamination	Nonvolatile gum residue, 41 mg/100 ml Stoved gum residue, 3.7 mg/100 ml
Fuel Resistance	Weight loss in TT-S-735, Type III fuel; 300:1 fuel to sealant volume ratio; 7 days at 130°F with 3 fuel changes, 10%
Resistance to Other Fluids	Excellent resistance to water, alcohols, petroleum and synthetic lubricating oils and petrouem-base hydraulic fluids.
Effect on Acrylic Plastics	Not recommended, as solvent will attack plastic.
Fungus Resistance	Non-nutrient

NOTE: The above application and performance values are typical for the material, but are not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions, and configurations.

PR-1321 CLASS A

SUPERSEDES
MARCH 1968

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